



Dart Aerospace Ltd.
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D3916-041
Job Sheet 183130



Part No: D3916-041

Job Qty: 8 ea

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Large Fab-5		CPC MTL
100	Large Fab	8 pcs	9/21/18	9/21/18	0.00	3.92	Large Fab 8		CPC MTL
105	QC	8 pcs	9/21/18	9/21/18	0.00	0.00	QC6		8/21/18
107	Large Fab	8 pcs	9/21/18	9/21/18	0.00	0.00	Large Fab 1		LE DAS
110	QC	8 pcs	9/21/18	9/21/18	0.00	0.00	QC5		NOV 02 2018 68
120	QC	8 pcs	9/21/18	9/21/18	0.00	0.00	QC10		NOV 02 2018 68
130	Packaging	8 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3 Large Fab		21 9-89
140	QC21-SA	8 Ea	9/21/18	9/21/18	0.00	0.00	QC21		21 NOV 02 2018

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other
Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg
D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
107 - 1- weld bushing as per dwg D3916 2- grind welds flush
130 - LOCATION: WA004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	56 Ea (7 ea)	90-Start up Operation	5105247
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	33.3280 ft (4.166 ea)	90-Start up Operation	5115491

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3759-1	56	134	0
	M304TS0.750W.049	33	844	0



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Container No: S122708



Part: D3916-041

Job No: 183130

Serial No/Batch: S122708

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/30/18

Plex 9/12/18 3:18 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					